

Date: Tuesday, 5/23/2006 8:36:36 AM
 User: Kim Johnston

Process Sheet

| | | | |
|-----------------------|---------------------------------------|------------------|---------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : CABLE GUARD |
| Job Number | : 27210 | | |
| Estimate Number | : 12410 | | |
| P.O. Number | : N/A | Part Number | : D34993 |
| This Issue | : 5/23/2006 S.O. No. : N/A | Drawing Number | : D3499 REV A |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : N/A Type : MACHINED PARTS | Drawing Revision | : A |
| Previous Run | : 27043 | Material | : N/A |
| Written By | : <u>SEE COMMENT BELOW</u> | Due Date | : 6/5/2006 |
| Checked & Approved By | : <u>06-05-23</u> | Qty: | 8 Um: Each |
| Comment | : Est Rev. A New Issue 06-05-05 JLM | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|-----------|----------------------------|
| 1.0 | MUHMWB625 | UHMW .625 Black Tivar 1000 |
|-----|-----------|----------------------------|



Comment: Qty.: 1.1351 sf(s)/Unit Total: 9.0804 sf(s)
 UHMW .625 Black Tivar 1000
 Batch: M101046

M 06 05 31

| | | |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET
 1-Cut as per Dwg D3499
 Dwg Rev: A
 Prog Rev: A

2-Deburr if necessary

M 06 05 31

(8)

| | | |
|-----|-----|----------------------------------------|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|----------------------------------------|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

M 06 05 31

(8)

| | | |
|-----|-------|--------------------------------|
| 4.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
|-----|-------|--------------------------------|



Comment:
 HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA636 Rev: AA & Dwg D3499 Rev: A




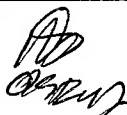
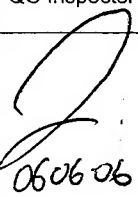
2-Deburr per dwg D3499


M 06/06/01

7

PTO

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|----------|------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------|-----------------------------------------|-------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| 06/06/06 | 4 | 1 piece scrap. Found a deep gouge in middle top section of the part. .5 Long .125 wide. .102 deep. Reason unknown. Could have been hit with the corner of a metal sheet on the rack. |  Initial | Scrap & destroy part. mark unacceptable |  Sign & Date |  Verification |  Approval Design Mgr |  Approval QC Inspector |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA:  Date: 06/08/09

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Tuesday, 5/23/2006 8:36:36 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CABLE GUARD

Job Number: 27210

Part Number: D34993

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

En 06/06/01

7

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

En 06/06/06

27

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST76*

AP 06/06/01 (7)

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SP 06/06/08

Job Completion



U 06.06.08

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

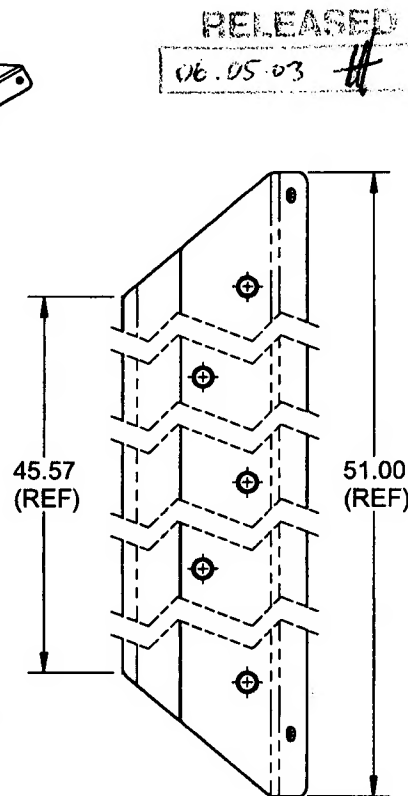
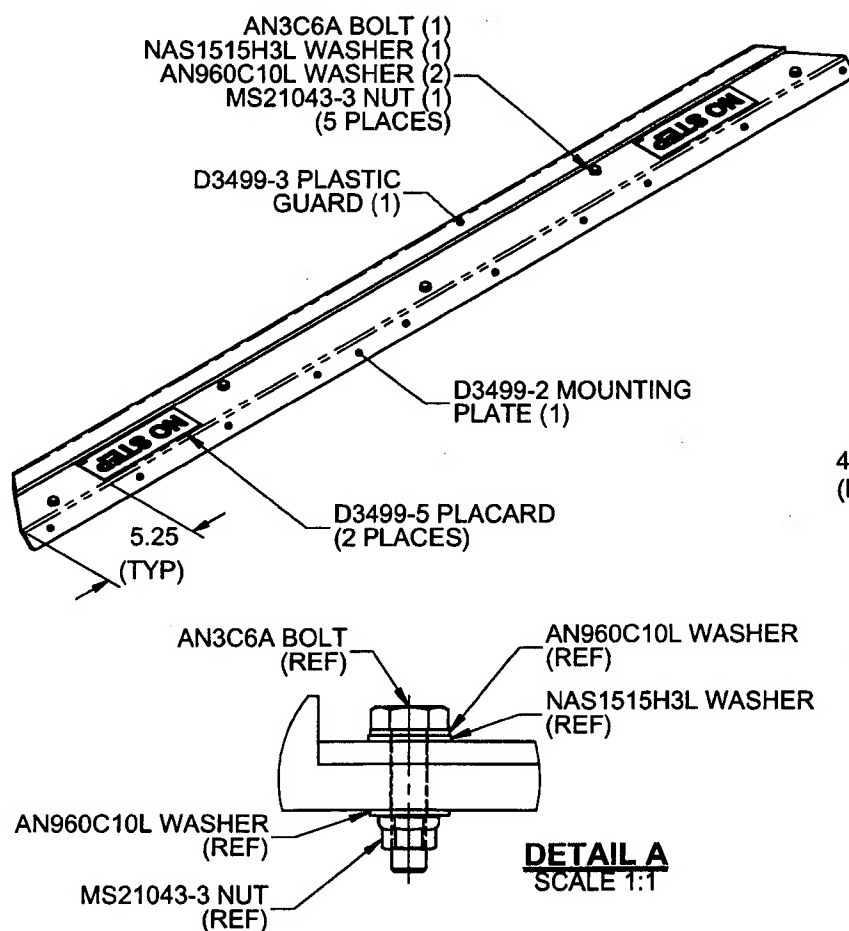
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

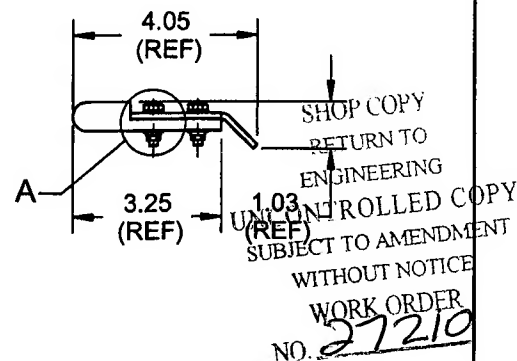


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| DATE 06.04.11 | | TITLE CABLE GUARD | SCALE 1:4 |
| A | 06.04.11 | NEW ISSUE | |



D3499-042 CABLE GUARD ASSEMBLY

| QTY -042 | P/N | DESCRIPTION |
|-------------|------------|----------------------|
| X | D3499-042 | CABLE GUARD ASSEMBLY |
| 1 | D3499-2 | MOUNTING PLATE |
| 1 | D3499-3 | PLASTIC GUARD |
| 2 | D3499-5 | PLACARD |
| 5 | AN3C6A | BOLT |
| 10 | AN960C10L | WASHER |
| 5 | MS21043-3 | NUT |
| 5 | NAS1515H3L | WASHER |



NOTES:

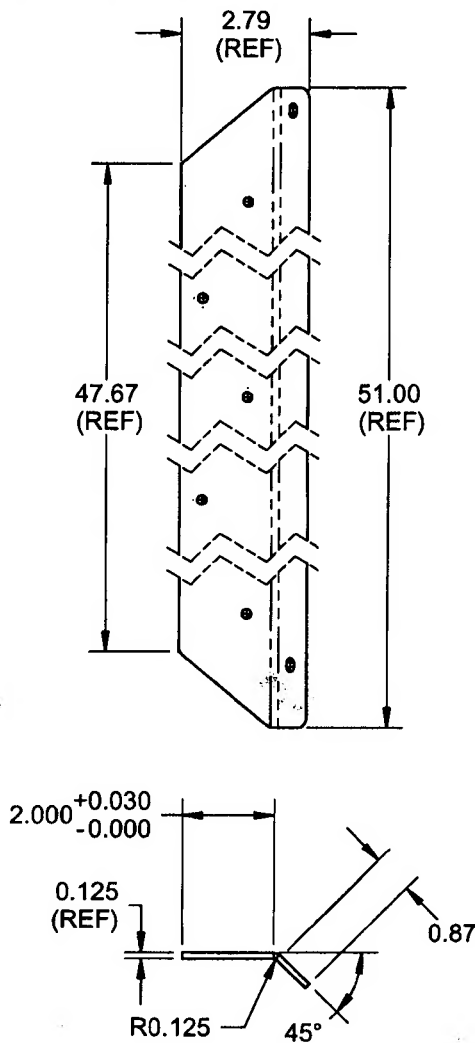
- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010

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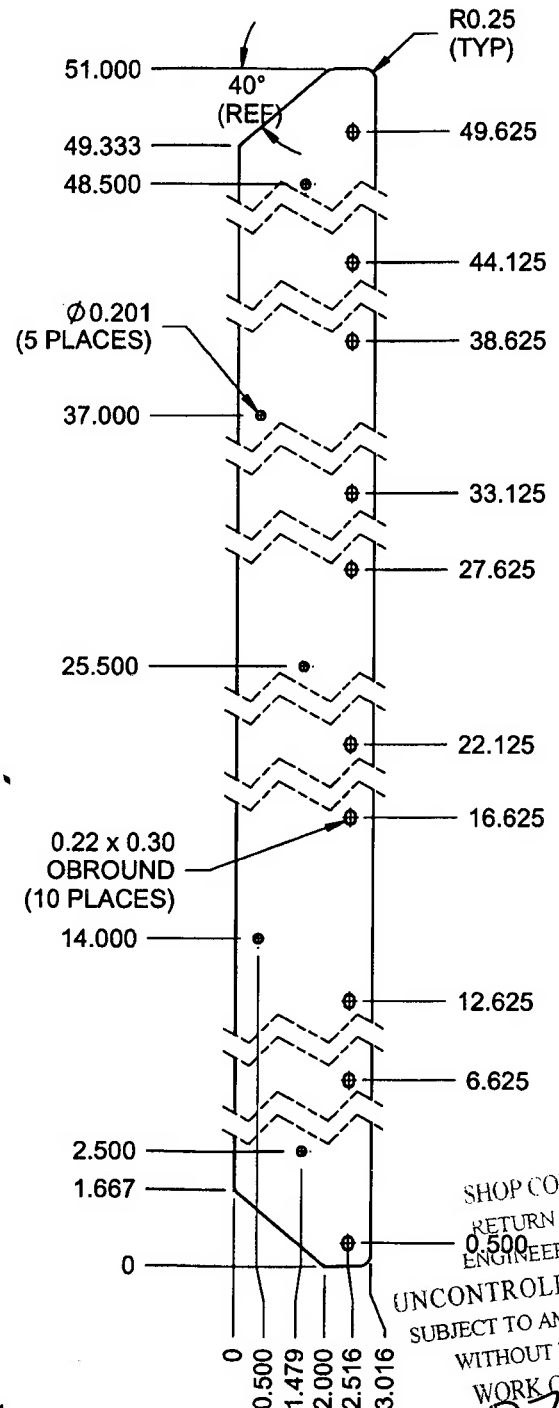
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| DATE 06.04.11 | | TITLE CABLE GUARD | SCALE 1:4 |

RELEASED
06-15-02 *[Signature]***D3499-2 MOUNTING PLATE****NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET (0.125 THICK)
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005. 4.1
POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

**D3499-2F MOUNTING
PLATE FLAT PATTERN**

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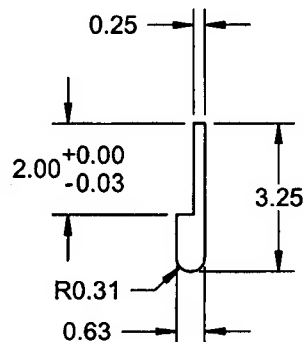
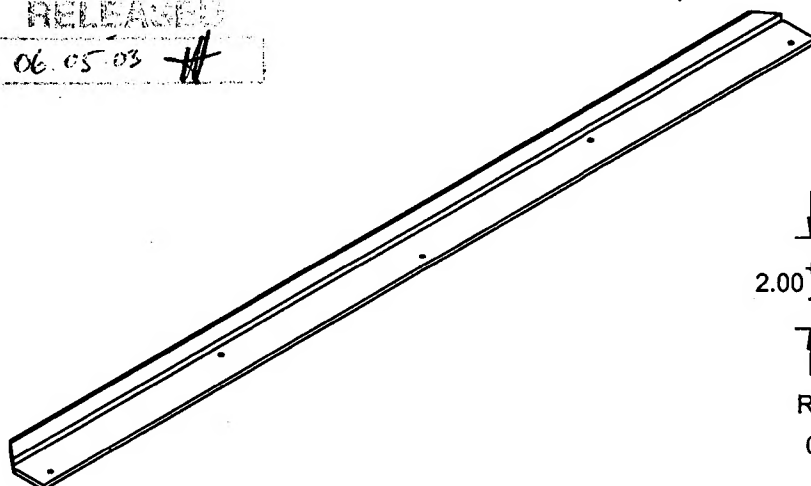
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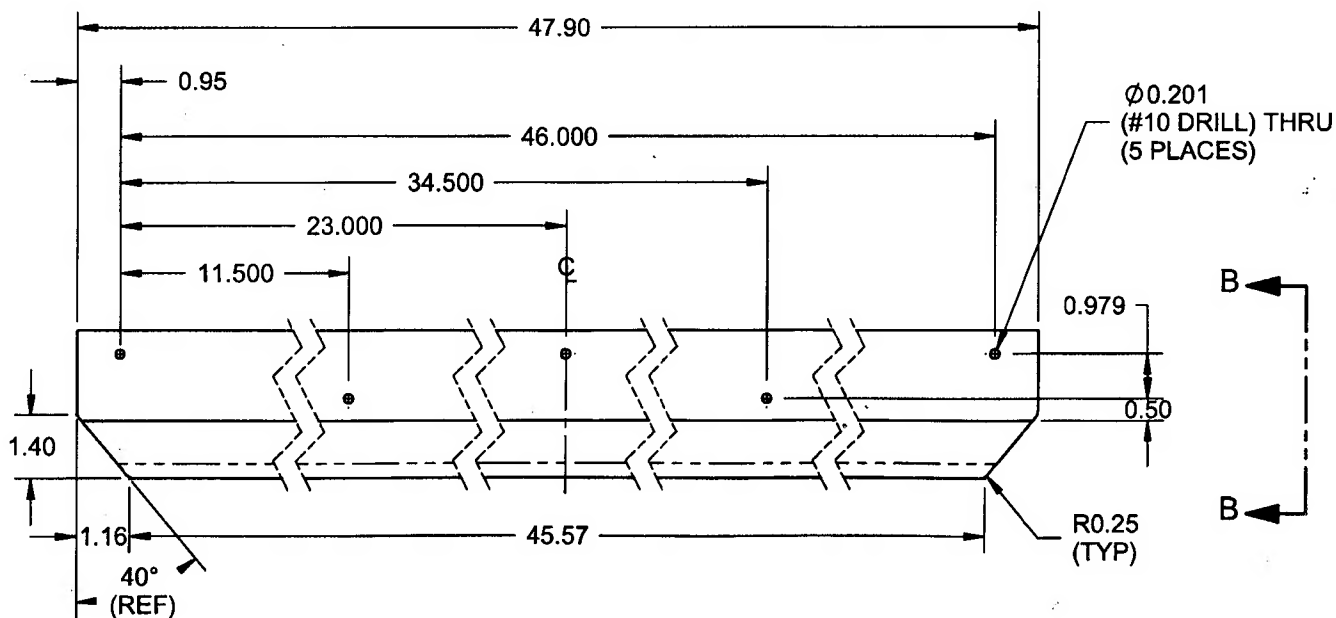


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| DATE 06.04.11 | | TITLE CABLE GUARD | SCALE 1:4 |

RELEASED
06.05.03 *[Signature]*



VIEW B-B



D3499-3 CABLE GUARD

NOTES:

- 1) MATERIAL: UHMW BLACK TIVAR 1000 VIRGIN MATERIAL (UHMWVB)
- 2) PART IS SYMMETRICAL AT CENTER LINE
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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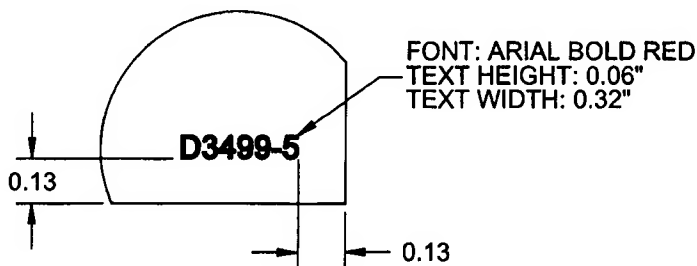
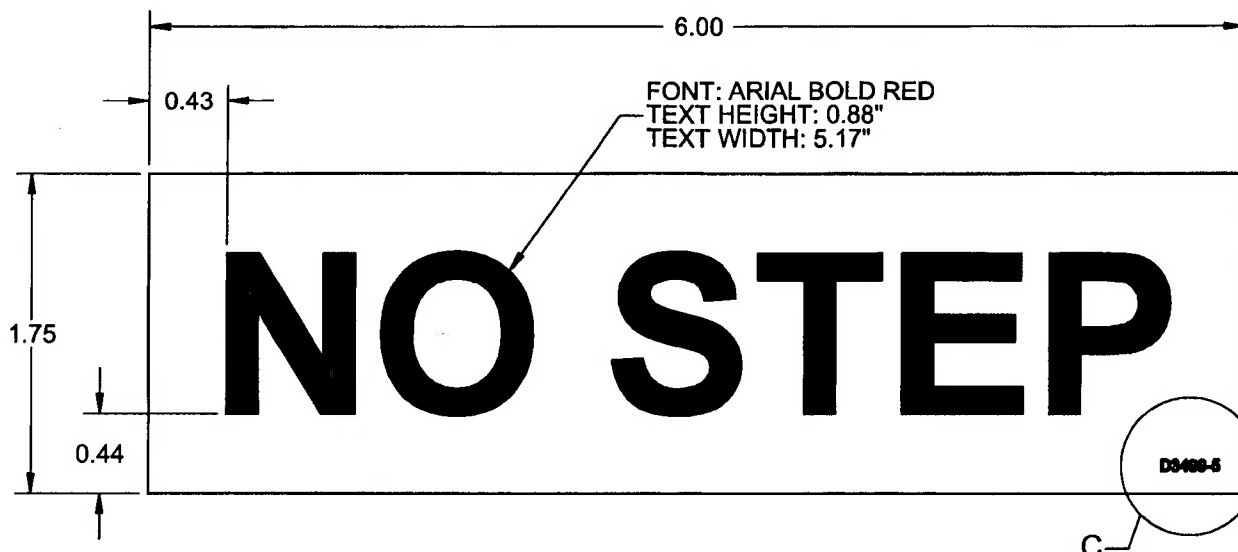
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| DATE 06.04.11 | | TITLE CABLE GUARD | SCALE 1:1 |

RELEASED
06-05-03 *[Signature]*



DETAIL C
SCALE 1:2

D3499-5 PLACARD

NOTES:

- 1) MATERIAL: RED LETTTERS ON WHITE ADHESIVE BACK VINYL
MANUFACTURED FROM 3M 7 MIL MASKING FILM #8522CP OR
AVERY IPM #2031. SIZE IS 6.00" LONG" x 1.75" WIDE
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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